

TECHNICAL DATA SHEET

TECHNYL A 208F BK 21N

TECHNYL A 208F BK 21N is an unreinforced polyamide PA66, heat stabilized, high fluidity, fast cycling grade, for injection moulding. This grade offers two main advantages: its good resilience and its excellent filling quality of moulds.

General

Feature	Heat-aging stabilized	Fast molding cycle
Polymer type	PA66 (Polyamide 66)	
Processing technology	Injection molding	
Certification	RoHS EC 1907/2006 (REACH)	UL-Yellow Card European Railways Certifications EN 45545-2
Applications	Fasteners	
Colors available	Black	
Forms	Pellets	

Product identification

ISO 1043 abbreviation	PA66
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Condition	Standard	Unit	Value
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Physical properties

	Condition	Standard	Unit	Value
Density		ISO 1183	g/cm ³	1.14
Water absorption	24 hr, 23°C	ISO 62	%	1.2

Mechanical properties

dam / cond.*


	Condition	Standard	Unit	Value
Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	3200 / 1600
Stress at break		ISO 527-1/-2	MPa	60 / 40
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	2900 / 1300
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	4.5 / 10
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	4.5 / 12

Thermal properties

	Condition	Standard	Unit	Value
Melting temperature, 10°C/min		ISO 11357-1	°C	263
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	75

	Condition	Standard	Unit	Value
Electrical properties				
Dielectric strength	1 mm	IEC 60243-1	kV/mm	22

Burning behaviour

UL Yellow Card availability 	Click here to have access to the UL Yellow Card → QMFZ2.E44716			
Flammability, 0.40 mm	0.40 mm	UL 94		V2
Flammability, 0.75 mm	0.75 mm	UL 94		V2
Flammability, 1.5 mm	1.5 mm	UL 94		V2
Flammability, 3.0 mm	3.0 mm	UL 94		V2
Glow-wire flammability index, GWFI, 1.5 mm	1.5 mm	IEC 60695-2-12	°C	800

*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	80 °C
Suggested max moisture	0.2 %
Rear temperature	265 - 275 °C
Middle temperature	270 - 280 °C
Front temperature	280 - 285 °C
Recommended mould temperature	60 - 80 °C

Injection notes

The material is supplied in airtight bags, ready for use. In case that the virgin material has absorbed moisture, it must be dried with a dehumidified air drying equipment, dew point minimum -20°C. Recommended time 2-4h.

Injection advice

For unfilled polyamides, Domo recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm). In the case of high requirements on surface quality a mould temperature of up to 120°C can be considered. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design.

Disclaimer

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